

D5018-1 SUPPORT, 214 AFT

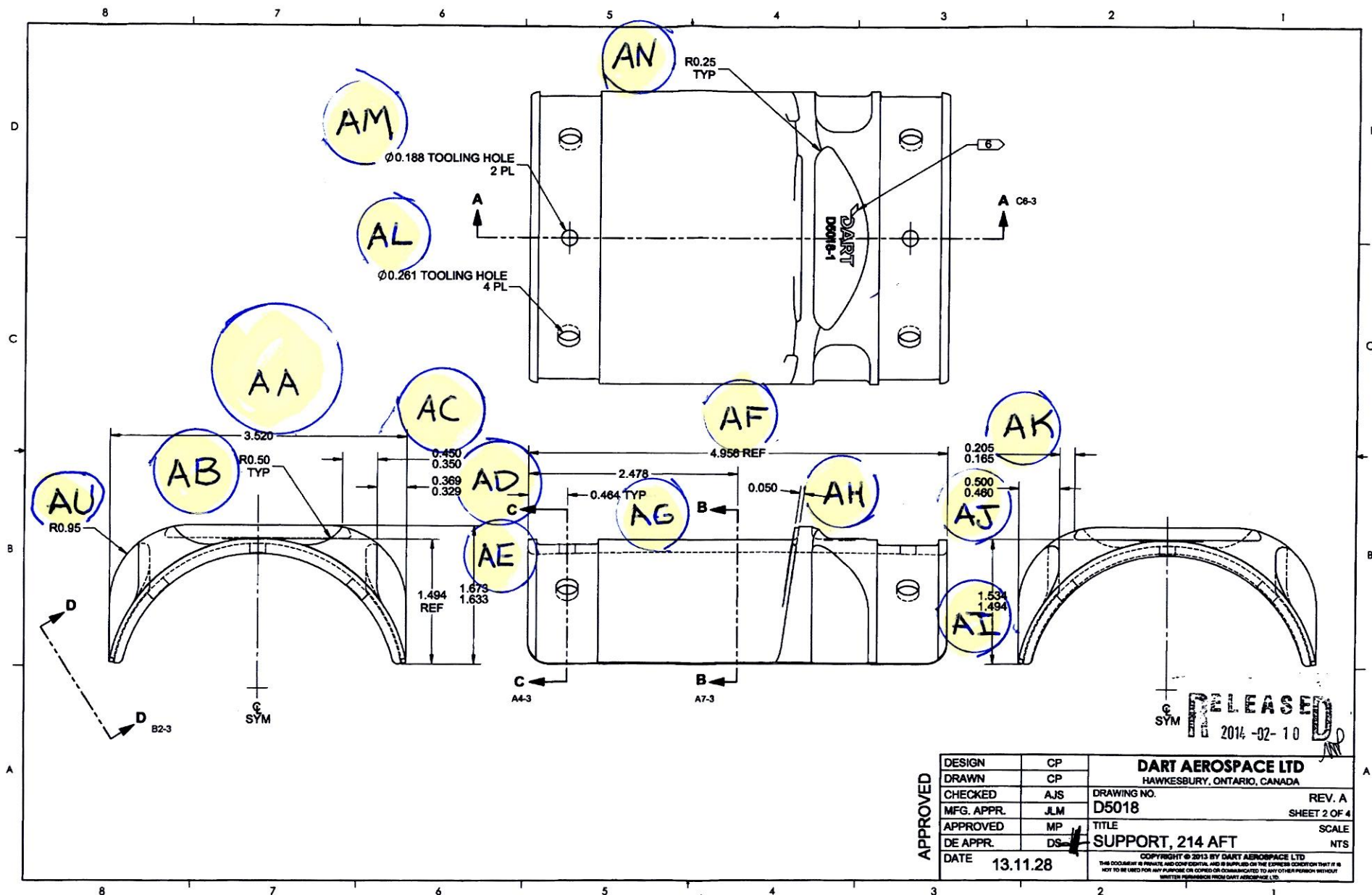
NOTES:

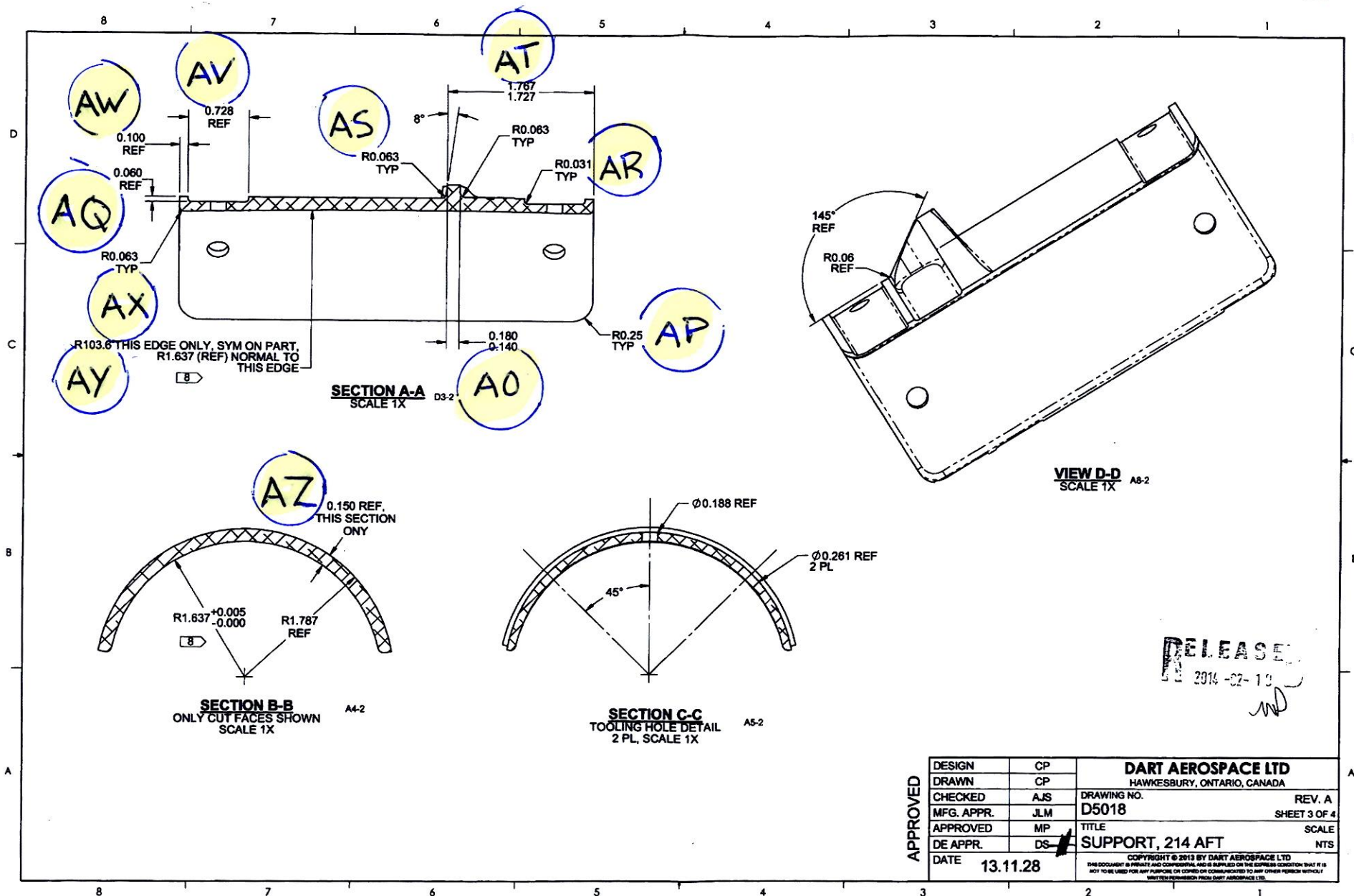
- 1) MATERIAL: MAKE FROM D5018-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N "D5018-1" IN THIS AREA WITH 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3
- 7) WEIGHT: 1.07 lbs
- 8) INNER CONCAVE SURFACE HAS A CONSTANT RADIUS OF R1.637 (REF) CUT ALONG AN R103.6 (REF) PATH (ie. TORUS SHAPE)
- 9) FOR ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIV.). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

A		NEW ISSUE		CP		13.11.28	
REV.		DESCRIPTION		BY		DATE	
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN	CP						
CHECKED	AJS	DRAWING NO.		REV. A			
MFG. APPR.	JLM	D5018		SHEET 1 OF 4			
APPROVED	MP	TITLE		SCALE			
DE APPR.	DS	SUPPORT, 214 AFT		NTS			
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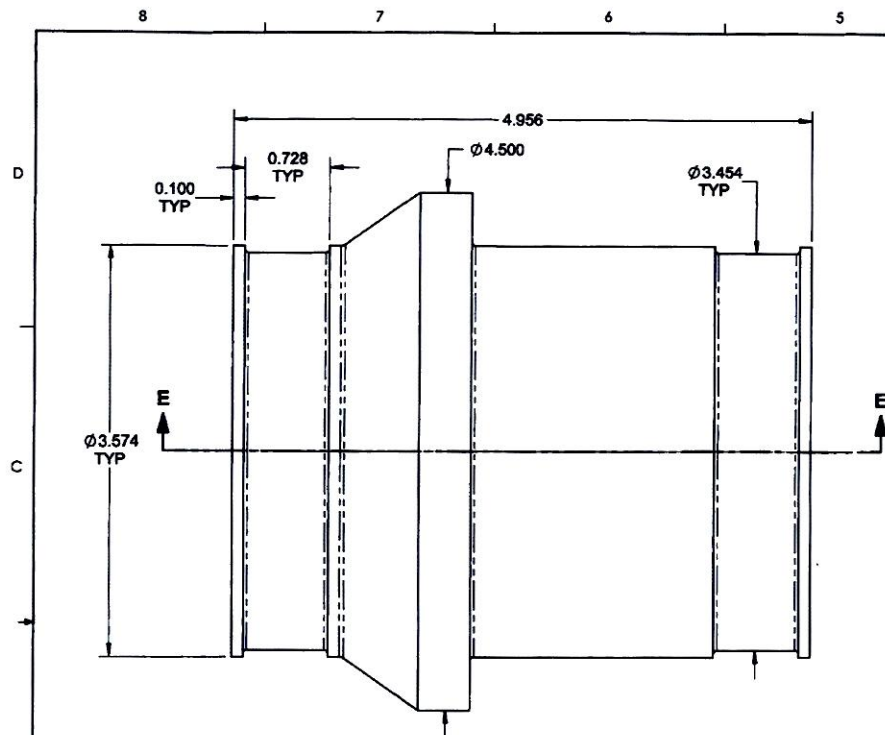
APPROVED

RELEASED
2016-02-10

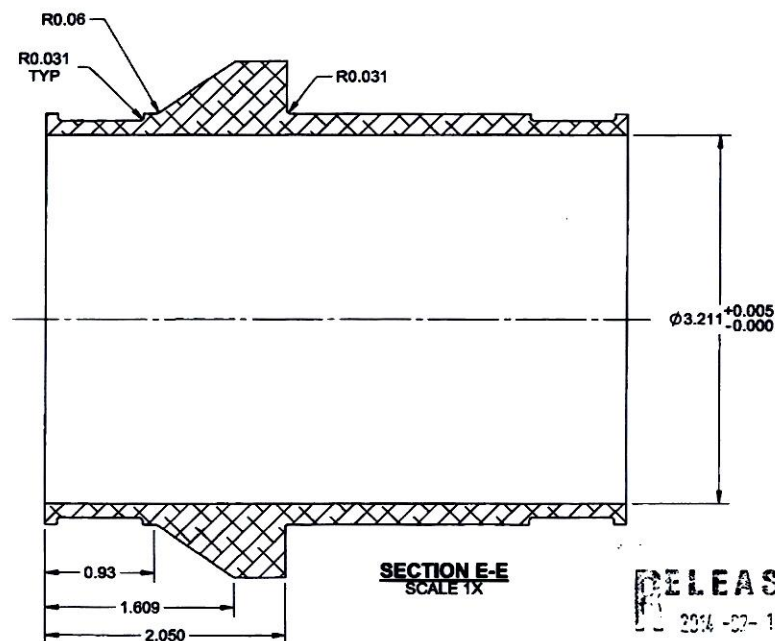
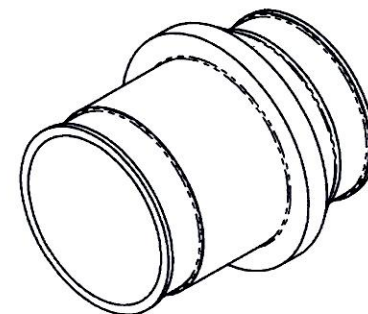




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	DRAWN	CP		
	CHECKED	AJS	DRAWING NO. D5018	REV. A
	MFG. APPR.	JLM	TITLE SUPPORT, 214 AFT	SHEET 3 OF 4
	APPROVED	MP		SCALE
	DE APPR.	DS		NTS
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D5018-1TRN TURNING DETAIL



SECTION E-E
SCALE 1X

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
REF DART SPEC. D6104
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.74 lbs

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	MFG. APPR.	JLM	D5018	SHEET 4 OF 4
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RELEASE
2014-02-10